

Date: Friday, 14/11/2008 10:21:35 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 43452	
Estimate Number : 12338	
P.O. Number :	Part Number : D3492045
This Issue : 14/11/2008 S.O. No. :	Drawing Number : D3492 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 42478	Material :
Written By :	Due Date : 28/11/2008 Qty: 100 Um: Each
Checked & Approved By : <u>JLD 08.11.14</u>	
Comment : Est Rev: A 06.03.21 New Issue JLM	
Est Rev: B 06-08-28 As per Rev B JLM	
Est Rev: C 07-12-06 as per rev c DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 6.5625 f(s)
 6061-T6 Round Bar .500"
 (M6061T6R500)
 Batch: M109396 08/11/17 JD

(108 pcs)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------

**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA634 & Dwg D3492
 Dwg Rev: C
 Folio Rev: AA

08/11/17 JD

(108 pcs)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

08/11/17 JD

(108 pcs)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

08/11/18 JD

(108)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary
 2-Tumble

8-11-19

(108)?

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 14/11/2008 10:21:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 43452

Part Number: D3492045

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

08/11/19

108

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



108

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/11/19

8.0

POWDER COATING

POWDER COATING



M 109 152



108X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:40
320°F
9:10

MF 08/11/21

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



108

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/11/24

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-13

MF 08-11-25

108

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-26

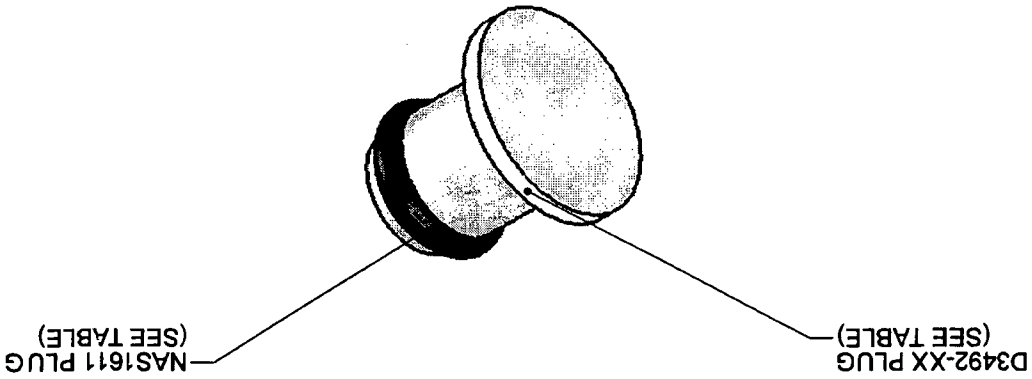
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3492-XXX PLUG PARTS LIST

QTY	-041	QTY	-043	QTY	-045	QTY	-047	QTY	-049	QTY	-051	QTY	-053	PART NUMBER	DESCRIPTION
X		X												D3492-041	PLUG ASSEMBLY
														D3492-043	PLUG ASSEMBLY
			X											D3492-045	PLUG ASSEMBLY
				X										D3492-047	PLUG ASSEMBLY
					X									D3492-049	PLUG ASSEMBLY
						X								D3492-051	PLUG ASSEMBLY
							X					X		D3492-053	PLUG ASSEMBLY
														D3492-1	PLUG
														D3492-3	PLUG
														D3492-5	PLUG
														D3492-7	PLUG
														D3492-9	PLUG
														D3492-11	PLUG
														D3492-13	PLUG
														NAS1611-005	O-RING
														NAS1611-007	O-RING
														NAS1611-010	O-RING
														NAS1611-012	O-RING
														NAS1611-013	O-RING
														NAS1611-015	O-RING
														NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

△
△
△

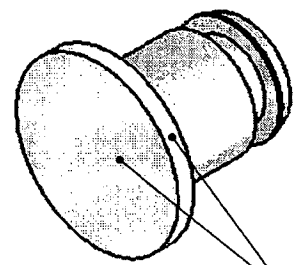
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		
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DART AEROSPACE LTD	HAWKESBURY, ONTARIO, CANADA	REV. C	SHEET 1 OF 2
D3492		TITLE	SCALE
PLUG			2:1

RELEASED
07.11.16/M

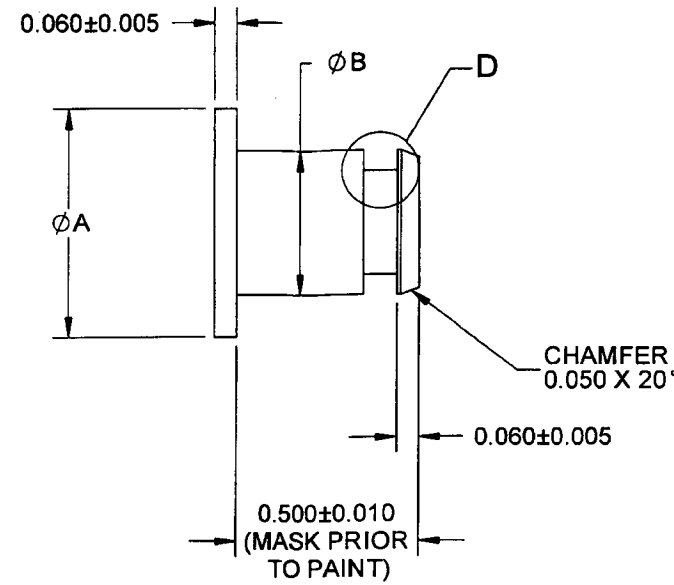
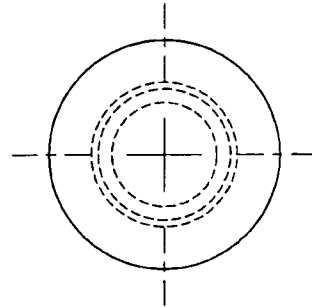
DEO ATTACHED
NO. 49352

UNDER REVIEW
07.04.11/04

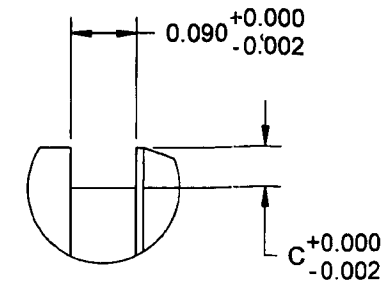
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WITHOUT NOTICE
WORK ORDER
NO. 49352



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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NO. 43752

UNDER REVIEW

01.04.21 RBA

DEM AB ON D3492-13
REQ. CK (MHE SHAWLER)

ASS 08.11.12

OKay

DEO ATTACHED

RELEASED
07.11.16

DESIGN	P4	DART AEROSPACE LTD	
DRAWN	P4	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05		DATE 08/11/05		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

WAS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

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08/11/05